

Date: Tuesday, 6/13/2006 3:29:02 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPRING CLIP ASSEMBLY
Job Number	: 27523		
Estimate Number	: 10645		
P.O. Number	: N/A	Part Number	: D2429041
This Issue	: 6/13/2006 S.O. No. : N/A	Drawing Number	: D2429 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/12/2006 Type : PURCHASED PARTS	Drawing Revision	: C1
Previous Run	: 25484	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/30/2006
Checked & Approved By	:	Qty:	3 Um: Each
Comment	: Est. D 02.03.06 Added note at step 7 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Dwg: C1
 Prog: C2



Comment: FLOW WATER JET

SAP 06:06:20

2.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.0500 sf(s)/Unit Total : 0.2500 sf(s)
 304/316 .040 Sheet

SAP 06:06:20

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr
 2-Bend D2429-1 as per Dwg D2429

SAP 06:07:04

SB 06/07/05

6.0	MS20470AD45	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

Date: Tuesday, 6/13/2006 3:29:02 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 27523

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

MS20470AD4-5

Rivet

MIX 461

7.0

AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty

Part number

Description

Batch

2

AN960JD6L

Washer

M5519

NOTE: 2 D2429-1 required for 1 assy.

SAD 06/07/20

(6)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

SAD 06/07/20

(3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.07.20 (3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5TH

AB 06/07/21

(3)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/24 (3)

Job Completion



06.07.24

Date: Monday, 6/12/2006 3:43:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPRING CLIP ASSEMBLY
Job Number	: 27523		
Estimate Number	: 10645		
P.O. Number	:	Part Number	: D2429041
This Issue	: 6/12/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2429 REV C1
First Issue	: / /	Project Number	: N/A
Previous Run	: 25484	Drawing Revision	: C1
	Type : PURCHASED PARTS	Material	:
Written By	:	Due Date	: 6/30/2006
Checked & Approved By	:	Qty:	5
Comment	: Est. D 02.03.06 Added note at step 7 NG	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Note: Qty 2 pieces required per assembly

Issue P/O

Make D2429-1 Flat Pattern as per Dwg D2429

Material release note required

Material: (M30450040)
 Batch M101264

2.0	D24291F	Spring Clip Ass'y
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Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spring Clip Ass'y

SAD 06:06:20

(6)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

QC2



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

SAD 06:06:20

(6)

4.0	QC 8	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06.06.22 (6)


5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2-Bend D2429-1 as per Dwg D2429

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-20	1	Add Note for 2 pieces req'd for 1 ASS'y. 26 parts = 12 x D2429-1 Perm. change.						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:43:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 27523

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part number Description Batch

1 MS20470AD4-5 Rivet

7.0

AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part number Description Batch

2 AN960JD6L Washer

NOTE: 2 D2429-1 required for 1 assy.

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

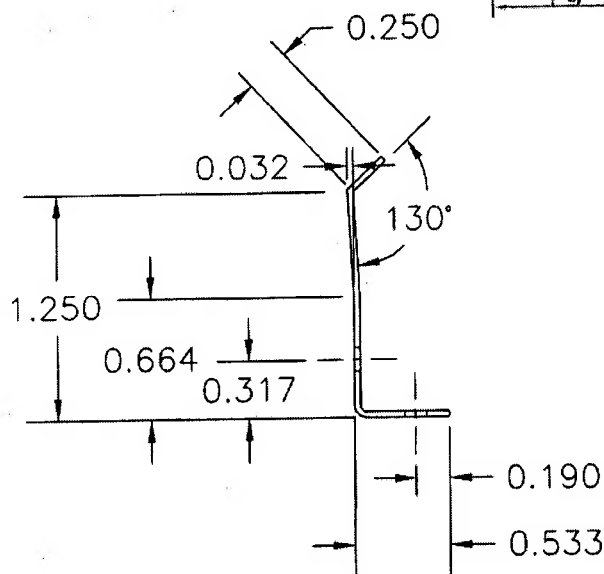
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

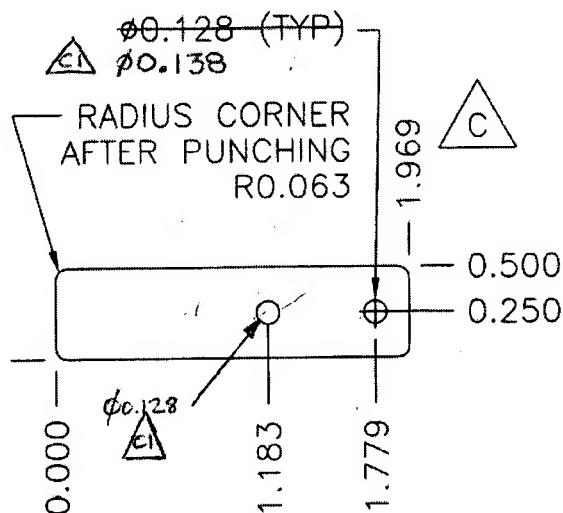


DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26	TITLE SPRING CLIP		SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	UP # 01.03.27	Ø0.138 WAS Ø0.128	

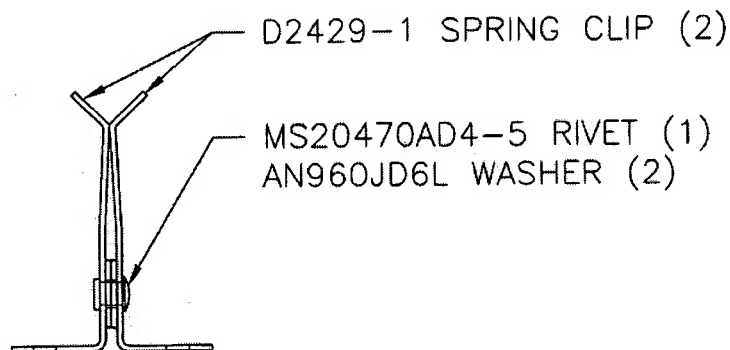
RELEASED
00.06.27 #



D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN



D2429-041 SPRING CLIP ASSEMBLY

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No. 27523

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